



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

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SWA6A-400  
Job Sheet 186995



ASAP

Part No: SWA6A-400

Job Qty: 10 ea

Part Name: Thrust Washer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA6A-400 Rev2 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 10 Ea  |            | 11/30/18 | 0.00      | 0.00    | Start Up Machining-3  |           |          |
| 110   | Mori Seiki         | 10 pcs |            | 11/30/18 | 0.00      | 2.50    | SL2500Y               |           |          |
| 120   | QC                 | 10 pcs |            | 11/30/18 | 0.00      | 0.00    | QC2                   |           |          |
| 130   | QC                 | 10 pcs |            | 11/30/18 | 0.00      | 0.00    | QC8                   |           |          |
| 140   | Packaging          | 10 pcs |            | 11/30/18 | 0.00      | 0.00    | Packaging3            |           |          |
| 150   | QC21-SA            | 10 Ea  |            | 11/30/18 | 0.00      | 0.00    | QC21                  |           |          |

Part Op Descriptions: 110 - 1-Machine as per DWG. FB708 FOLIO REV: AA DWG REV: 2 2-Deburr

### Job BOM

| Part / Item             | Component Name                 | Quantity           | Operation             | Container      |
|-------------------------|--------------------------------|--------------------|-----------------------|----------------|
| MT-BRONZE-C63000-R2.250 | Bronze C63000 Round Bar 2.250" | .1700 ft (.017 ea) | 90-Start up Operation | <u>5110450</u> |

### Job Allocations

| Operation             | Component Part          | Required | Inventory | Allocated |
|-----------------------|-------------------------|----------|-----------|-----------|
| 90-Start up Operation | MT-BRONZE-C63000-R2.250 | 0        | 0         | 0         |

### Part Specifications

Specifications could not be found.



Container No: S133694



Part: SWA6A - 400

Job No: 186995

Serial No/Batch: S133694

Revision: 2

Inspector:

Exp Date:

Instructions:

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Plex 11/23/18 1:28 PM Dart.lajeunesse.marie

Date: 12/01/18



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                      |                          |                                   |                          |            |                          |                     |                          |             |                          |
|--------------------------------------------------------------|----------------------|--------------------------|-----------------------------------|--------------------------|------------|--------------------------|---------------------|--------------------------|-------------|--------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b>   |                          | <b>AGAINST DEPARTMENT/PROCESS</b> |                          |            |                          |                     |                          |             |                          |
|                                                              | Rework               | <input type="checkbox"/> | Skid-tube                         | <input type="checkbox"/> | Cross tube | <input type="checkbox"/> | Water Jet           | <input type="checkbox"/> | Engineering | <input type="checkbox"/> |
|                                                              | Scrap                | <input type="checkbox"/> | Machining                         | <input type="checkbox"/> | Small Fab  | <input type="checkbox"/> | Prod. Eng. Coord.   | <input type="checkbox"/> | Quality     | <input type="checkbox"/> |
|                                                              | Use-as-is            | <input type="checkbox"/> | Thermoforming                     | <input type="checkbox"/> | Finishing  | <input type="checkbox"/> | Rec/Store/Packaging | <input type="checkbox"/> | Other       | <input type="checkbox"/> |
|                                                              | Suspected Unapproved | <input type="checkbox"/> | Large Fab                         | <input type="checkbox"/> | Composite  | <input type="checkbox"/> | Supplier            | <input type="checkbox"/> |             |                          |

|        |         |                 |                       |
|--------|---------|-----------------|-----------------------|
| Date : | Step #: | QTY Effective : | MRB (QSI042) Approval |
|--------|---------|-----------------|-----------------------|

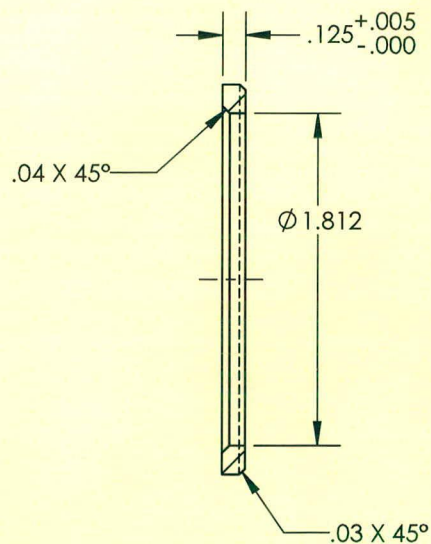
|                                  |             |                                              |
|----------------------------------|-------------|----------------------------------------------|
| Description Work Order Deviation | Disposition | Completed By                                 |
|                                  |             | Lead hand / Supervisor Approval Verification |
|                                  |             |                                              |
|                                  |             | QC / QA Coordinator Approval                 |

| Root Cause         |                          |                       | FAULT CATEGORY         |                          |                                   |
|--------------------|--------------------------|-----------------------|------------------------|--------------------------|-----------------------------------|
| Environment        | <input type="checkbox"/> | No Re-verification    | Pressure/Forced        | <input type="checkbox"/> | Temperature/Cure                  |
| Design             | <input type="checkbox"/> | Operator              | Bending                | <input type="checkbox"/> | Set-up                            |
| Doc/Data           | <input type="checkbox"/> | Offset/Setup          | Centre Not Concentric  | <input type="checkbox"/> | BOM/Route                         |
| Equip/Tooling      | <input type="checkbox"/> | Supplier              | Cracks                 | <input type="checkbox"/> | Broken/Damage/Defect              |
| Handling/Pre       | <input type="checkbox"/> | Training              | Crimp/Kink/Ripple/Wave | <input type="checkbox"/> | Inspection Incomplete/Unqualified |
| Material           | <input type="checkbox"/> | Use for Testing       | Cuffs                  | <input type="checkbox"/> | Contamination                     |
| Internal Transport | <input type="checkbox"/> | Poor Information      | Crushing               | <input type="checkbox"/> | Countersink                       |
| Tribal Knowledge   | <input type="checkbox"/> | Rushing               | Heat Treat             | <input type="checkbox"/> | Cut Too Short                     |
| LOA                | <input type="checkbox"/> | Product Improvement   | Wave/Twist in Tube     | <input type="checkbox"/> | Instructions Incomplete/Unclear   |
| Substation         | <input type="checkbox"/> | Process Improvement   | Marks/Chatter          | <input type="checkbox"/> | Drill Holes                       |
| Past Expiry Date   | <input type="checkbox"/> | Manufacturing Process |                        |                          |                                   |
| Misidentified      | <input type="checkbox"/> | Past Due              | OTHER :                |                          |                                   |



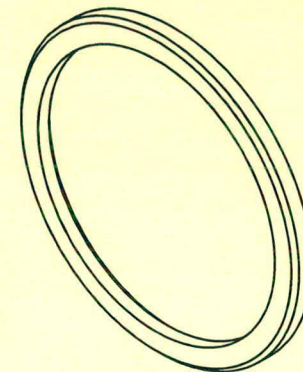
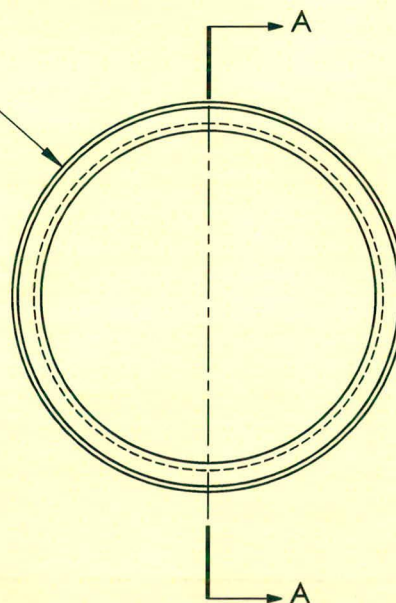
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| REVISIONS |                                         |            |         |
|-----------|-----------------------------------------|------------|---------|
| REV       | DESCRIPTION                             | DATE       | INITIAL |
| 1         | AS DRAWN BY CANAM                       | 11/19/2012 | JAG     |
| 2         | CH'D TOL. ON OD FROM 2.125+/.001/-/.001 | 11/19/2012 | JAG     |



SECTION A-A

Ø 2.1261  
2.1253



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 186995 MJS  
18-11-23

|                                                                                                 |                                                        |
|-------------------------------------------------------------------------------------------------|--------------------------------------------------------|
| <b>RED BARN MACHINE</b>                                                                         |                                                        |
| <b>THRUST WASHER</b>                                                                            |                                                        |
| DWG NO. SWA6A-400                                                                               | REV 2                                                  |
| MAT'L AL-BRONZE 630                                                                             | DRAWN BY: CANAM                                        |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX ± .005<br>.XX ± .01<br>.X ± .1   | APPROVED <i>D Weil</i><br>HEAT TREAT<br>FINISH<br>SPEC |
| 1. BREAK ALL SHARP EDGES .015 x 45°<br>OR .015R<br>2. DIMENSIONAL LIMITS APPLY AFTER<br>PLATING | USED ON MODEL                                          |
| SCALE 1:1                                                                                       | DATE 2/4/2002                                          |
| SHEET 1 OF 1                                                                                    |                                                        |

| ASSY QTY | ASSY QTY | B/O | Part #    | UNIT QTY | Description   | Material      | B/O INFORMATION OR SPECIFICATIONS |
|----------|----------|-----|-----------|----------|---------------|---------------|-----------------------------------|
|          |          |     | SWA6A-400 | 1        | THRUST WASHER | AL-BRONZE 630 | Ø2-1/4 X 1/4                      |







